

Work Order ID 75114

Monday, October 17, 2011 2:33:01 PM

75114

Page 1

ASAP

Item ID: D3371-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Lock Base
 Start Date: 10/17/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/17/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 11-10-17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

100 BAND SAW 0.00
100 Memo 0.00
 Bandsaw Cut blank: 2.00" x 2.25" x 7.370" long
 Jeaspa Bandsaw

F.K 11/10/19 4 0

110 HAAS CNC VERTICAL MACHINING #1 0.00
110 Memo 0.00
 HAAS 1 Machine D3371-1 as per Folio FA486 and Dwg D3371DeburFinish 8-32
 HAAS CNC vertical machine #1 thread by handIdentify as D3371-1

B.A 11/10/24 4 0
SL 11-10-25

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120 Memo 0.00
 QC Quality Control

B.A 11/10/24 4 0
SL 11-10-25

Pto 7

W/O: 75114		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D33711 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 11/10/28 Date: 11-10-28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 11/10/31

NCR: 11-945		WORK ORDER NON-CONFORMANCE (NCR) 1162.49						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/24	110	Tap 8-32 broke into part on 3 rd opp. Rec Process. tap too much with loss.	S AS2042 11/10/25	Scrap + Destroy Qty + 1 Repl B 118072	B.A 11/10/24	only 11/10/26	S 11/10/25 AS2042	S 11/10/25
		Process						

NOTE: Date & initial all entries

Work Order ID 75114

75114

Page 2

Monday, October 17, 2011 2:33:01 PM

Item ID: D3371-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pedal Lock Base
Start Date: 10/17/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/17/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
145	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
145									
Powdercoat	Memo	0.00							
Powder Coating									
	POWDER COAT:								
	Start Time:								
	Oven Temperature:								
	Finish Time:								

mk 11/10/26

4xØ m / 11/10/26

4xØ m / 11/10/26

M116345

12:15
3200F
12:45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Picklist Print

Monday, October 17, 2011 2:33:01 PM

Page 1

Work Order ID: 75114

Parent Item: D3371-1

Parent Item Name: Pedal Lock Base

Start Date: 10/17/2011

Required Date: 10/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.01.18New issueKJ/JLMIPP RevB: add powdercoat DD 10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.250 6061-T6 Bar 2.00 x 2.25		Purchased	No			100	f	6.7200	0.625	2.6315789			

Location

Loc Qty

Loc Code

MAT009

6.72

118072

6.72

2.632 EK 10/18/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 75/14
Description: Pedal Lock Base		Part Number: D3371-1
Inspection Dwg: D3371	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	+/-0.5°	60°	✓		Angle finder	CNC-03
2.25	+/-0.030	2.249	✓		Vern	GA-01
1.650	+/-0.010	1.651	✓		"	"
1.648	+/-0.010	1.650	✓		"	"
0.700	+/-0.010	0.702	✓		"	"
3.955	+/-0.010	3.995	✓		"	"
0.600	+/-0.010	0.598	✓		"	"
0.104	+/-0.010	0.106	✓		"	"
0.305	+/-0.010	0.300	✓		"	"
45°	+/-0.5°	45°	✓		Angle finder	CNC-03
0.672	+/-0.010	0.675	✓		Vern	GA-01
Ø1.300	+/-0.010	Ø1.297	✓		"	"
1.450	+/-0.005	1.450	✓		"	"
7°	+/-0.5°	7°	✓		Angle finder	CNC-03
2.00	+/-0.030	1.997	✓		Vern	GA-01
1.125	+/-0.010	1.123	✓		"	"
Ø1.125	+/-0.010	Ø1.126	✓		"	"
R0.500	+/-0.010	R0.500	✓		R-6	ref.
1.000	+/-0.010	0.9985	✓		Vern	GA-01
0.375	+/-0.010	0.373	✓		"	"
Ø0.203	+0.005/-0.000	Ø0.204	✓		"	"
7.19	+/-0.030	7.191	✓		CNC-02	Vern
4.500	+/-0.010	4.500	✓		Vern	GA-01
0.500	+/-0.010	0.500	✓		"	"

Measured by: D.A.
Date: 11/10/24

Audited by: <i>amk</i>
Date: 11/10/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

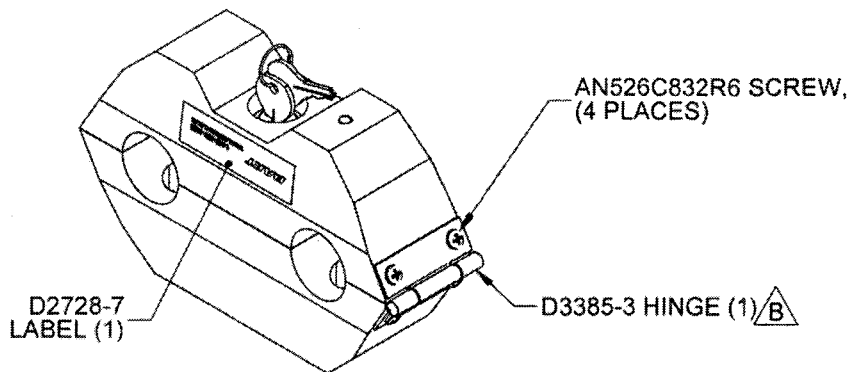
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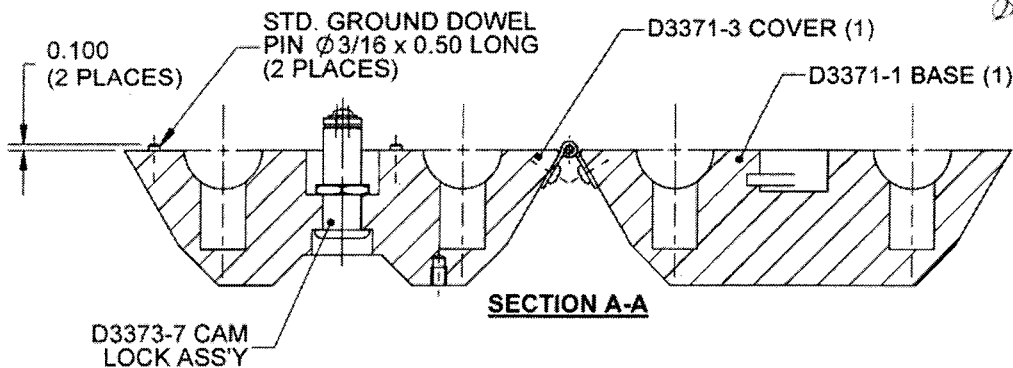


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

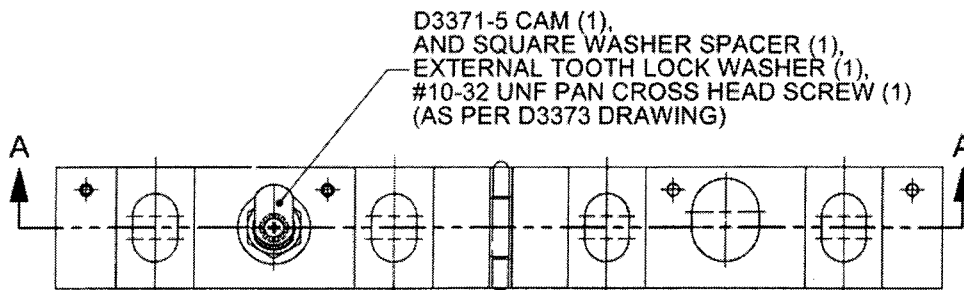


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SECTION A-A



#75114

D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

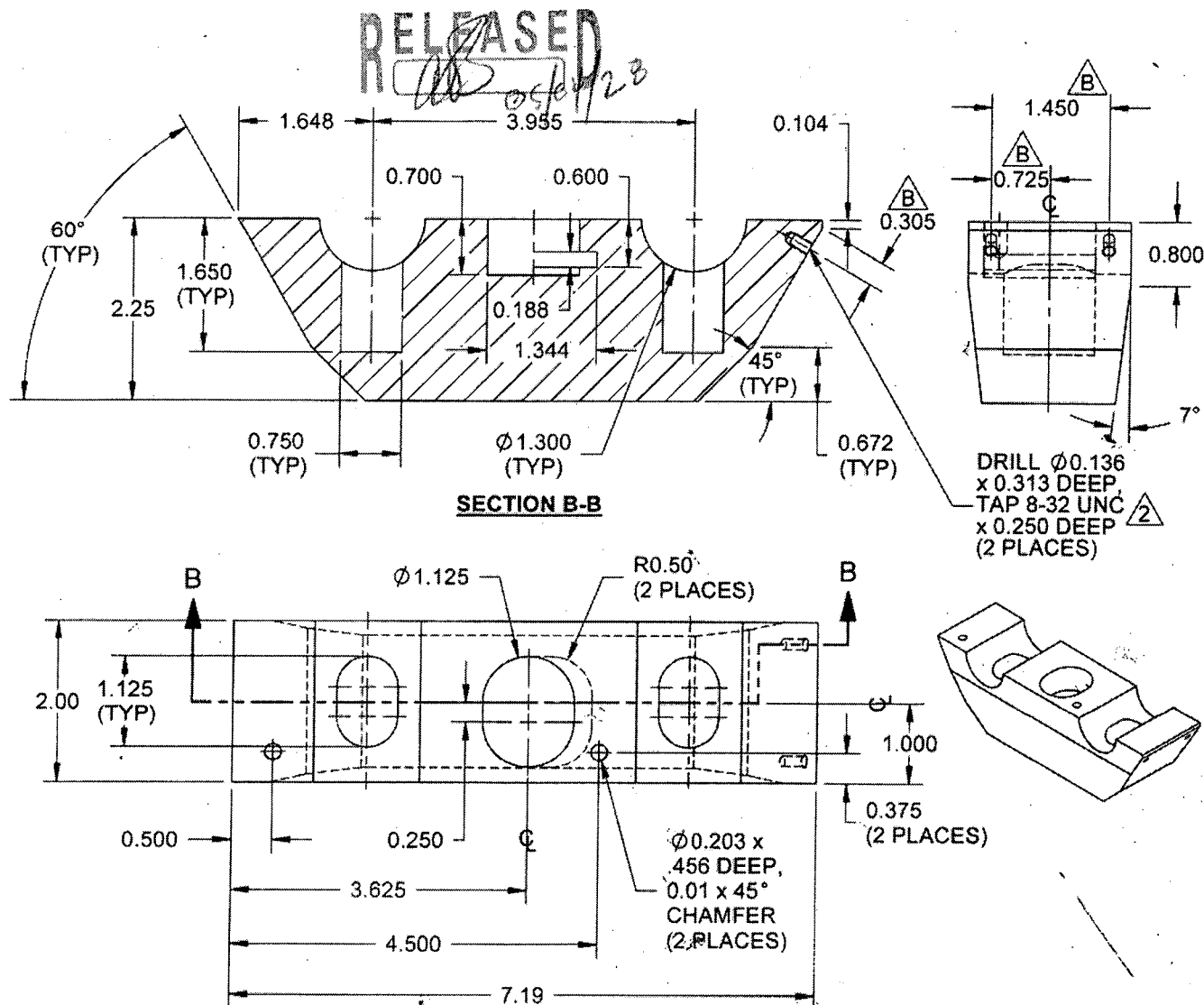
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #5	DRAWN BY #3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #7	APPROVED #1	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK SCALE 1:2		



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

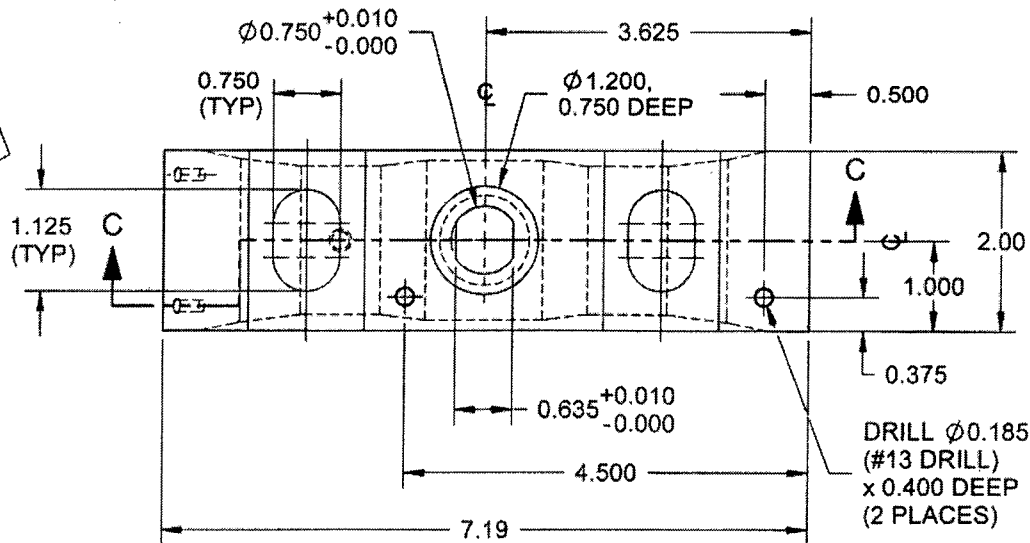
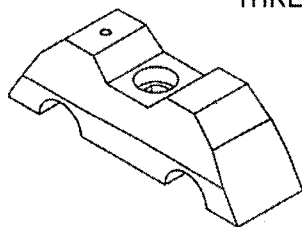
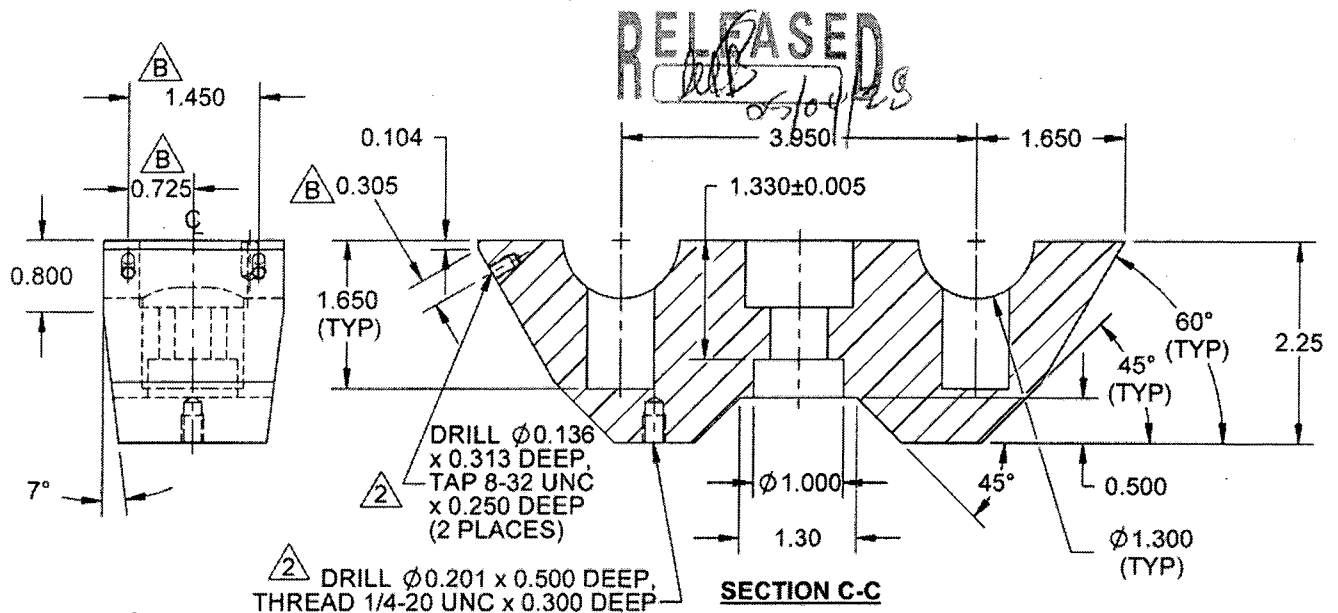
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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
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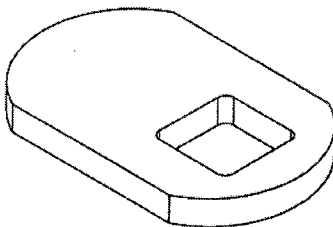
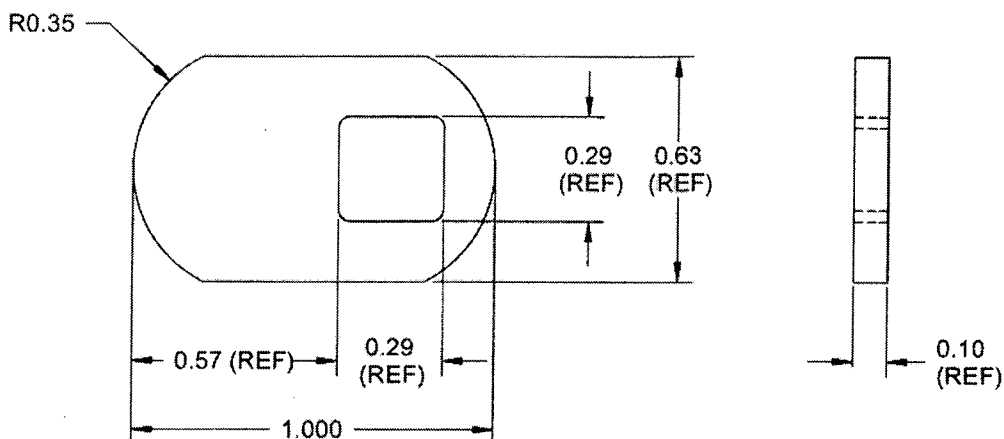
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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